



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3562-042
Job Sheet 173040



Part No: D3562-042

Job Qty: 1 ea

Part Name: Step Weldment



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/26/18

Job Tracking No:

Due Date: 3/20/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV G IPP Rev:A New Issue 06-11-09 JLM IPP rev B ECN 987 07.10.09 EC verified by: DD IPP Rev:C ECN1048 07-12-18 DD verified by: EC IPP Rev:D 08-07-28 add chemical conversion coat DD verf:EC IPP REV:E 13.06.03 PER DWG REV:F DD VERF:JLM IPP REV:F 16.06.23 AS PER DWG REV.G DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/19/18	0.00	0.00	Start Up Large Fab-4		DC 2018-03-05
100	Large Fab	1 pcs		3/19/18	0.00	1.42	Large Fab 8		CPC 18-03-05
110	QC	1 pcs		3/19/18	0.00	0.00	QC5		CPC
120	HandFinish	1 pcs		3/19/18	0.00	0.25	HandFinish1		SA 18-03-06
130	QC	1 pcs		3/19/18	0.00	0.00	QC7-2		CPC
140	Small Fab	1 pcs		3/19/18	0.00	2.25	Small Fab-4		DC 2018-03-06
150	QC	1 pcs		3/19/18	0.00	0.00	QC5		CPC
160	Large Fab	1 pcs		3/19/18	0.00	1.42	Large Fab 2		CPC
170	QC	1 pcs		3/19/18	0.00	0.00	QC10		D 18-3-12
180	QC	1 pcs		3/19/18	0.00	0.00	QC5		D 18-3-12
190	HandFinish	1 pcs		3/19/18	0.00	0.25	HandFinish1		SA 18-3-12
200	Powdercoat	1 pcs		3/19/18	0.00	0.34	Powdercoat1		BA 18-3-13
205	SprayPaint	1 pcs		3/19/18	0.00	0.00			
210	HandFinish	1 pcs		3/20/18	0.00	0.25	HandFinish3		BEB 18-03-13
215	QC	1 pcs		3/20/18	0.00	0.00	QC3		3-00
220	QC	1 pcs		3/20/18	0.00	0.00			
230	Packaging	1 pcs		3/20/18	0.00	0.00	Packaging3-1		Smr
240	QC21-SA	1 Ea		3/20/18	0.00	0.00	QC21		

Part Op 100 - 1-Cut D2622 extrusion as per Dwg D3562

Descriptions: 140 - 1- Transfer drill Rivet holes as per dwg D3562.

160 - 1-Weld end caps as per Dwg D3562 & QSI 004 Inspect for foreign objects as per QSI 024

200 - START TIME: 9:10 A.T. 3:30 FINISH: 9:40. M136760.

205 - Prime Tempo Grey 4500-P-23 per QSI005 4.2.1.3.2

wing walk M138761

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	1 Ea (1 ea)	90-Start up Operation	5046116
D2734	Step End Plate	2 Ea (2 ea)	140-Small Fab	5012001
D3560-042	Arm Weldment	1 Ea (1 ea)	140-Small Fab	5045485
D3560-044	Arm Weldment	1 Ea (1 ea)	140-Small Fab	5045610
MS20600-AD4W4	Rivet	32 Ea (32 ea)	140-Small Fab	50257838

5047815

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation 140-Small Fab	D2622-120C	1	8	0
	D2734	2	27	0
	D3560-042	1	0	0
	D3560-044	1	0	0
	MS20600-AD4W4	32	1,841	0

Part Specifications

Specifications could not be found.

Plex 2/26/18 7:33 AM dart.lacelle.linda

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation				Disposition			
				Completed By			
				Lead hand / Supervisor Approval Verification			
				Coordinator Initial			
				Wrong dimensions or tolerance rect Missing id			
				Sequence			

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Email: sales@dartaero.com
www.dartaerospace.com

Int:

Tri:



Container No: S047815

Part: D3562-042

Job No: 173040

Serial No/Batch: S047815

Revision:

Inspector:

Master Unit 001396



Job No

173040

start up op: 90

Master Unit 001465



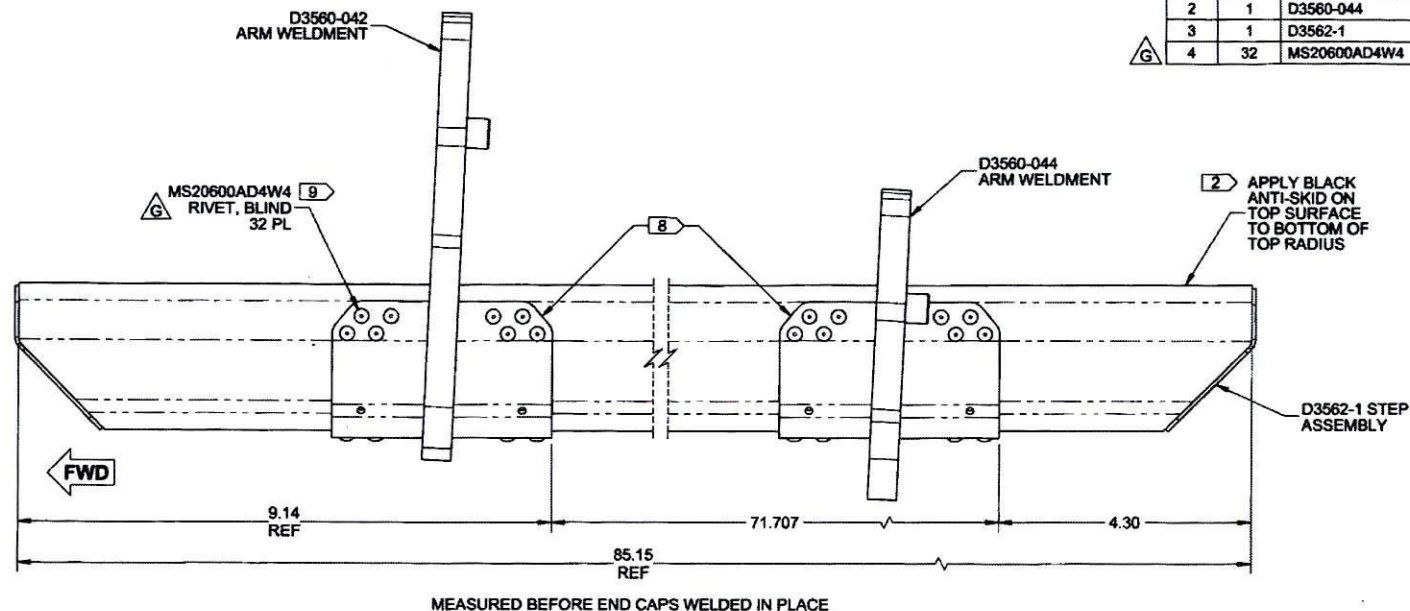
Job No

173040

op: 140

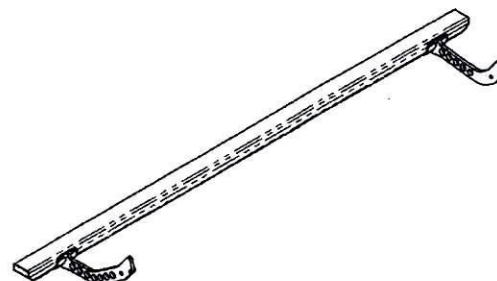
8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
	X	D3562-042	RH STEP WELDMENT
1	1	D3560-042	ARM WELDMENT
2	1	D3560-044	ARM WELDMENT
3	1	D3562-1	STEP ASSEMBLY
4	32	MS20600AD4W4	RIVET, BLIND



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH:
 - i) POWDER COAT ASSEMBLY:
 - GLOSS WHITE (4.3.5.1) OR
 - GREY SANDETEX (4.3.5.6) OR
 - BLACK SANDETEX (4.3.5.7) OR
 - GREEN SANDETEX (4.3.5.8) PER DART QSI 005 4.3
 - ii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 8.80 lbs
- 8) INSTALL ARM WELDMENTS WITH A LAYER OF SCOTCH-WELD DP460 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH SCOTCH-WELD DP460. CLEAN OFF EXCESS BEFORE POWDER COATING.
- 9) TRANSFER DRILL #30 DEBURR & TOUCH UP HOLES WITH CHEMICAL CONVERSION COAT BEFORE RIVETING



D3562-042 RH STEP ASSEMBLY

RELEASED

2016 JUN 22 4P

APPROVED

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	MB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ML	DRAWING NO.	REV. G
MFG. APPR.	DD	D3562	SHEET 2 OF 3
APPROVED	WM	TITLE	SCALE
DE APPR.	DS	STEP ASSEMBLY	NTS
DATE	16.04.21	COPYRIGHT © 2006 BY DART AEROSPACE LTD	

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